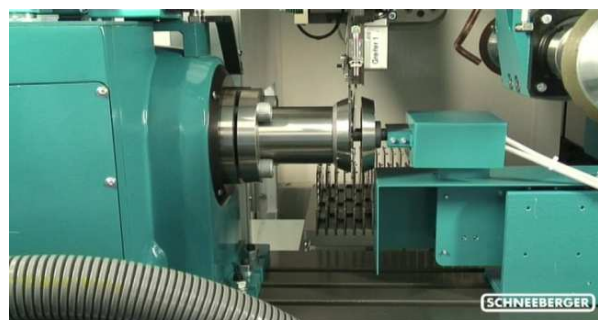
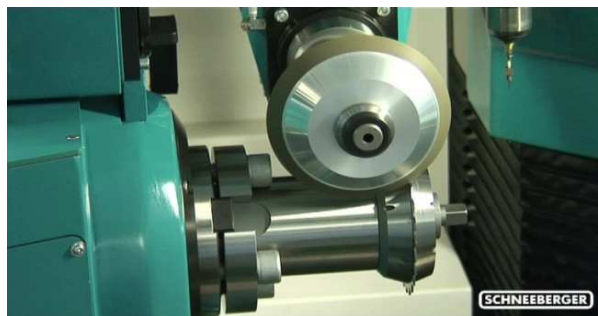
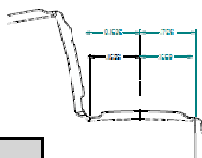
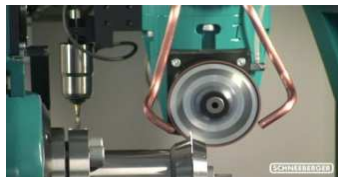
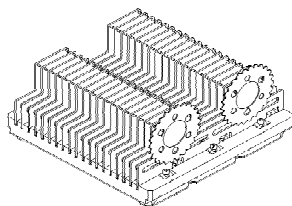







Radiator-Blade Ø115 Z26

A30-200

Radiator Blades are used in forming process of metalsheets of radiators. In function of the size of the sheet several blades are mounted on one arbor. The required precision in keeping the size and the special geometry of the clearance is tight. The presented solution with a linear loader allows an automatic production over 38 parts. Indexing is given by the specially designed clamping.



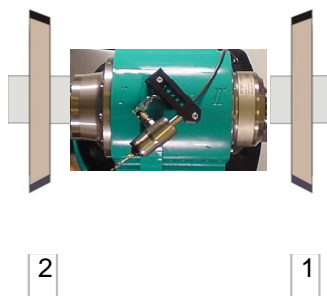
1. Cycletime for Production

Workpiece:	Blade in size without clearance, Ø115, t=1.2 mm		
	Material HSS		
Operations			
	Right Side	Left Side	Load
Feed [mm/Min]	100	100	5000
Power [kW]	1	1	
Cutting speed [m/s]	32	32	
Used wheels			
	1	2	
Grinding time [s]	121	121	45
Total cycle time	4 Min 46		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø125 B126
2	1V1 Ø125 B126



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Control: Fanuc 31i

Accessories: MIL, special Clamping

Responsible engineer: OP, 18.1.14

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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